Work Order ID 61083

August 5, 2010 12:49:03 PM

Item ID: D2842-042 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Step Assembly RH, 206 Float

Start Date: 8/05/10 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 8/13/10 **Req'd Qty:** 2.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D2842 / Rev B									
100	Large Fab	0.00							
Large Fab	**Memo**	0.00				2	∅		
Large Fab	1-Cut D2842-1 using D2622 extrusion as per Dwg D2842□2-Drill D2842-1 using Jig DT8272 as per Dwg D2842□3-Deburr and bevel ends for welding								
110	Large Fab	0.00							
Large Fab	**Memo**	0.00				2	∅		
Large Fab	1-Weld one end cap and (2) lugs as per Dwg D2842□A/R Batch: M112360 M114242 2-Grind end cap weld flush		AL Rod						
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	**Memo**	0.00				*2	∅	BE 10-08-11	
Quality Control									

10.08.10

10.08.11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00				x2 RH			
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 **Memo**	0.00 0.00				(2)			
150 QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00				(2)			

Work Order ID 61083

August 5, 2010 12:49:04 PM

Item ID: D2842-042 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Step Assembly RH, 206 Float

Start Date: 8/05/10 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 8/13/10 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
Large Fab	Large Fab								
Large Fab	**Memo**	0.00							
Large Fab	1-Remove alodine prior to welding. ☐ Weld end cap as per Dwg D2842.☐A/R AL Rod Batch: M112360 ☐2-Grind end cap weld flush.					10.08.12 2			
170	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	**Memo**	0.00							
Quality Control						(2) RD 10.08.12			
180	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control		8 10/08/12				42 RH			

Work Order ID 61083

August 5, 2010 12:49:04 PM

Item ID: D2842-042 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Step Assembly RH, 206 Float

Start Date: 8/05/10 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 8/13/10 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	**Memo**	0.00				2	0		
Powder Coating	START TIME: 11:45am ☐OVEN TEMPERATURE: 12:15pm ☐FINISH TIME: 320°C								
200	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00							
Quality Control									
210		0.00							
HandFinish	HandFinishing								
Hand Finishing	**Memo**	0.00							
	1-Install inserts as per Dwg D2842☐2-Wing Walk as per Dwg D2842 and QSI 005 4.1☐Batch: M115028								

PTO =>

=> M 10/08/12

M 10/08/12 (2)

← M 10/08/12 2 0

Work Order ID 61083

August 5, 2010 12:49:05 PM

Item ID: D2842-042 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Step Assembly RH, 206 Float

Start Date: 8/05/10 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 8/13/10 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC5- Inspect part completeness to step on W/O	0.00				60			
QC	**Memo**	0.00							
Quality Control									
230	Identify as per dwg & Stock Location:_____	0.00							
Packaging	**Memo**	0.00							
Packaging									
240	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

10/08/13 61083 10/8/13 10/08/16 10-8-13

Picklist Print

August 5, 2010 12:49:01 PM

Work Order ID: 61083

Parent Item: D2842-042

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 8/05/10 **Required Date:** 8/13/10

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM□□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960C10L	NAS1149C0332R	Purchased	No			100	Each	29.0000	3	6			
washer						XM 115000				X6 MH 10/08/12			
				Location			**Loc Qty**		**Loc Code**				
				ST245			29						
					107534		29						
D2622-120C		Manufactured	No			110	Each	95.4200	1	2			
Step Extrusion										MH 10.08.10			
				Location			**Loc Qty**		**Loc Code**				
				WA			95.42						
					55214		3.42						
					58544		92			2			
D2734		Manufactured	No			110	Each	7.0000	2	4			
Step End Plate										MH 10.08.11			
				Location			**Loc Qty**		**Loc Code**				
				WA			7			4			
					55014		7						
D3459-1		Manufactured	No			110	Each	32.0000	2	4			
Float Step Mounting Plate										MH 10.08.11			
				Location			**Loc Qty**		**Loc Code**				
				WA			32						
					48138		10						
					51583		22			4			

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

August 5, 2010 12:49:01 PM

Work Order ID: 61083

Parent Item: D2842-042

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 8/05/10 **Required Date:** 8/13/10

Start Qty: 2.00 **Required Qty:** 2.00

D3459-3	Manufactured	No		210	Each	18.0000	2	4

Float Step Mounting Plate

Location	Loc Qty	Loc Code
WA	18	
46988	1	
~~51630~~	17	

4

MS27039C1-07	Purchased	No		210	Each	21.0000	3	6

screw

Location	Loc Qty	Loc Code
ST293	21	
~~111424~~	21	

X6 M 10/08/12

NAS1329C3KB130	Purchased	No		210	Each	84.0000	3	6

insert

Location	Loc Qty	Loc Code
ST276	84	
~~111981~~	84	

X6 M 10/08/12

NAS1515H3L	Purchased	No		210	Each	434.0000	3	6

WASHER

Location	Loc Qty	Loc Code
FG	40	
102472	40	
ST277	394	
~~111819~~	148	
113362	246	

X6 M 10/08/12

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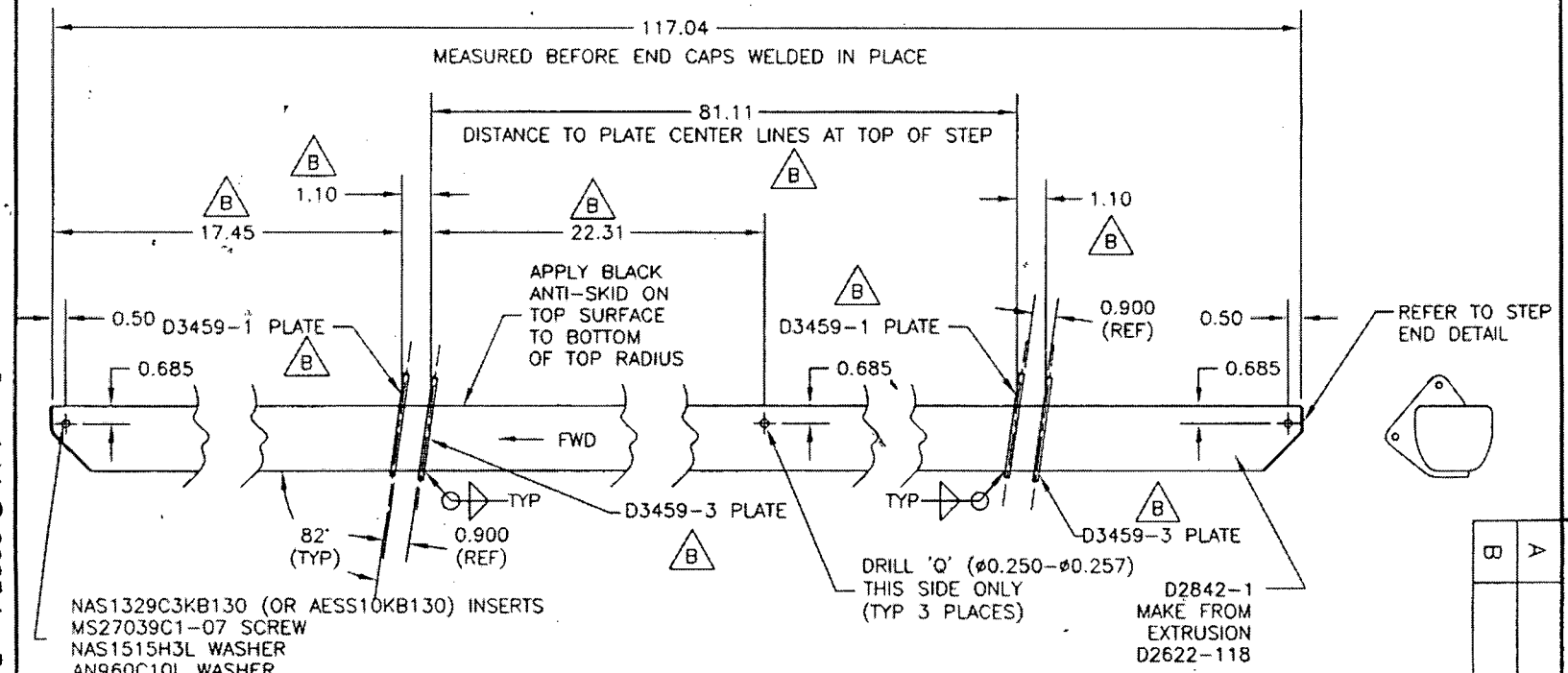
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

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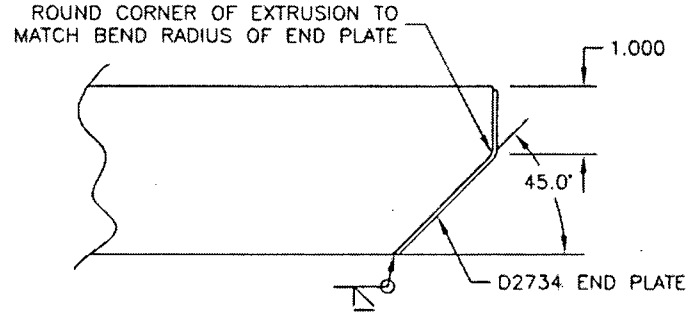


D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER



TYPICAL STEP END DETAIL
NOT TO SCALE

RELEASED 05.11.14

D2842-041/-042 FLOAT STEP ASSEMBLY

1) MAKE FROM EXTRUSION D2622
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
 APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ECO 60083

B		05.09.23
A	98.10.13	NEW ISSUE
	05.09.23	RE-DESIGN, ADD D3459-1/-3

DESIGN: KE | DRAWN BY: PH | CHECKED | APPROVED | DATE: 05.09.23

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. D2842 REV. B
TITLE 206L/407 FLOAT STEP ASSEMBLY
SCALE NTS SHEET 1 OF 1

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